



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2933-2

Job Sheet 180985



Part No: D2933-2

Job Qty: 4 ea

Part Name: Saddle RH In, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/19/18

Job Tracking No:

Due Date: 8/3/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP: B 00.06.26 New DWG rev (mpp 2069) EC IPP Rev:C As per Rev C 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		8/3/18	0.00	0.00	Start Up Machining-1		SBL 18/07/31
100	CNC Vertical Machining	4 pcs		8/3/18	0.92	4.12	HAAS1-2		SBL 18/08/01
110	Mill Conv	4 pcs		8/3/18	0.00	0.67	Mill Conv 1		SBL 18/08/01
120	QC	4 pcs		8/3/18	0.00	0.00	QC1		SBL 18/08/01
130	QC	4 pcs		8/3/18	0.00	0.00	QC8 Machining-1		mark 18/08/09
140	HandFinish	4 pcs		8/3/18	0.00	0.17	HandFinish1		D.P. 18/08/09
150	Powdercoat	4 pcs		8/3/18	0.00	0.17	Powdercoat1		lll 18-08-16 DAS
160	QC	4 pcs		8/3/18	0.00	0.00	QC3		AUG 2 0 2018 38
170	Packaging	4 pcs		8/3/18	0.00	0.00	Packaging3-1	57396 6	AUG 2 2018 9-89
180	QC21-SA	4 Ea		8/3/18	0.00	0.00	QC21	9-89	21 9-89 AUG 2 4 2018

Part Op 100 - Program part number and batch number.

Descriptions: 110 - Machine Keyway and inspect per attached dimension sheet

120 - Inspect on CMM as per folio CMMA011.

150 - START TIME: 8:30pm 9:00pm 32045

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	4 Ea (1 ea)	90-Start up Operation	5011637 55097686

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-001	4	77	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																
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Description Work Order Deviation Dart Aerospace Ltd. 1270 Aberdeen Street Hantsbury, ON K0A 1K7 CANADA TEL: 1 813 632-6200 Email: sales@dartaero.com www.dartaerospace.com Container No: S097835 Part: D2933-2 Job No: 180985 Serial No/Batch: S097835 Revision: Inspector: Exp Date: Instructions: Various STC's Date: 07/31/18				Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																																																		
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DART AEROSPACE LTD	Work Order:	180985
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.123	.123	.123	.122		
B	0.100	0.140		.123	.123	.123	.123		
C	0.100	0.140		.114	.113	.112	.113		
D	0.210	0.230		.225	.225	.225	.225		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.257	.257	.257	.257		
L	0.312	0.317		.312	.312	.312	.312		
M	0.235	0.240		.239	.239	.238	.239		
N	0.100	0.140		.126	.126	.126	.126		
O	0.540	0.560		.551	.549	.549	.548		
P	0.490	0.510		.500	.500	.501	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	3.490	3.490		
S	0.240	0.270		.254	.251	.251	.253		
T	0.100	0.180		.137	.133	.130	.128		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.125	1.145		1.135	1.135	1.135	1.135		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	DAS
Date:	57 18/08/01 9-89

Audited by:	229ml
Date:	18/08/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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								Lead hand / Supervisor Approval Verification																	
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
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